



Dart Hawkesbury
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D4776-1

Job Sheet 168118



Part No: D4776-1

Job Qty: 6 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/22/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: GLOSS BLACK

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		11/21/17	0.00	0.00	Start Up Machining		
100	Doosan	6 pcs		11/21/17	0.54	3.19	Doosan		
105	QC	6 pcs		11/21/17	0.00	0.00	QC2		
111	QC	6 pcs		11/21/17	0.00	0.00	QC8		
112	HandFinish	6 pcs		11/21/17	0.00	0.17	HandFinish1		
113	QC	6 pcs		11/21/17	0.00	0.00	QC7		
115	Powdercoat	6 pcs		11/22/17	0.00	0.07	Powdercoat1		
116	QC	6 pcs		11/22/17	0.00	0.00	QC3		
130	Packaging	6 pcs		11/22/17	0.00	0.00	Packaging3		
140	QC21-SA	6 Ea		11/22/17	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

M 120898. START: 10:45 O.V.T. 320° FINISH: 11:15.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R1.500	2	13	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850		
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428		
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350		
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615		
5	Basket Strut Clevis	1.750Inches ± 0.030	1.780 1.720		
6	Basket Strut Clevis	3.500Inches ± 0.030	3.530 3.470		
7	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle	
8	Basket Strut Clevis	0.030Inches ± 0.030	0.060		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

			0.000	
9	Basket Strut Clevis	0.060Inches $\pm$ 0.030	0.090 0.030	Radius
10	Basket Strut Clevis	0.196Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.202 0.195	Diameter
11	Basket Strut Clevis	0.261Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.267 0.260	Diameter
12	Basket Strut Clevis	0.410Inches $\pm$ 0.030	0.440 0.380	Radius
13	Basket Strut Clevis	1.130Inches $\pm$ 0.030	1.160 1.100	
14	Basket Strut Clevis	0.188Inches $\pm$ 0.010	0.198 0.178	
15	Basket Strut Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	
16	Basket Strut Clevis	0.500Inches $\pm$ 0.030	0.530 0.470	
17	Basket Strut Clevis	0.750Inches $\pm$ 0.010	0.760 0.740	
18	Basket Strut Clevis	0.403Inches $\begin{matrix} + 0.000 \\ - 0.005 \end{matrix}$	0.403 0.398	Diameter
19	Basket Strut Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius
20	Basket Strut Clevis	0.750Inches $\begin{matrix} + 0.010 \\ - 0.000 \end{matrix}$	0.760 0.750	
21	Basket Strut Clevis	0.160Inches $\pm$ 0.030	0.190 0.130	
22	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle

Plex 11/9/17 3:29 PM dart.poulin.mario

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AEROSPACE
S010806

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Basket Strut Clevis

PART NO:

D4776-1

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 11/16/17

Job No: 168118

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

